

CLAIMS:

1. A tightening band comprising:

5 a band main body including a ring portion formed by bending a metallic elongated band plate and a band protrusion formed by overlapping and welding a predetermined length of both end portions of the metallic elongated band plate such that the both end portions face each other;

10 a lever plate whose top side is protruded outward from the top of the band protrusion and which is fixed to the band protrusion by being welded thereto such that the end side of the lever plate is in contact with the outer periphery of the ring portion of the band main body; and

a lever-plate fixing member which is fixed to the band main body by being welded thereto so as to fix the top portion of the lever plate to the band main body,

15 the diameter of the ring portion of the band main body being reduced by tilting the lever plate until the surface of the lever plate is brought into contact with the outer periphery of the ring portion of the band main body while the end side of the lever plate serving as the fulcrum, so as to apply a tightening force to a member to be tightened,

20 wherein a pattern of projections and depressions is formed on the surface of each of the band main body, the lever plate, and the lever-plate fixing member.

2. A tightening band comprising:

25 a band main body including a ring portion formed by bending a metallic elongated band plate and a band protrusion formed by overlapping

and fixing a predetermined length of both end portions of the metallic elongated band plate such that the both end portions face each other;

a lever plate whose top side is protruded outward from the top of the band protrusion and which is fixed to the band protrusion such that the end
5 side of the lever plate is in contact with the outer periphery of the ring portion of the band main body; and

a lever-plate fixing member for fixing the top portion of the lever plate to the band main body,

the diameter of the ring portion of the band main body being reduced
10 by tilting the lever plate until the surface of the lever plate is brought into contact with the outer periphery of the ring portion of the band main body while the end side of the lever plate serving as the fulcrum, so as to apply a tightening force to a member to be tightened,

wherein a pattern of projections and depressions is formed on at least
15 the inner periphery of the band main body and the surface of the lever plate which contacts the band main body.

3. A tightening band comprising:

a band main body including a ring portion formed by bending a
20 metallic elongated band plate, a predetermined length of both end portions of the metallic elongated band plate being overlapped,

the diameter of the ring portion of the band main body being reduced so as to apply a tightening force to a member to be tightened,

wherein a pattern of projections and depressions is formed on at least
25 the inner periphery of the band main body.

4. A tightening band according to Claim 1 or 2, wherein, when fixing for forming the band protrusion, fixing between the band protrusion and the lever plate, or fixing between the band main body and the lever-plate fixing member is performed by welding, the pattern of projections and depressions
5 is formed at least so that each member to be welded contacts each other at many points inside the diameter of a spot to be welded.
5. A tightening band according to Claim 1, 2, or 3, wherein the pattern of projections and depressions is formed by providing a plurality of linear
10 depressions in a mesh pattern on the surface.
6. A tightening band according to Claim 5, wherein the depth of each depression is 2 μm to 30 μm .
- 15 7. A tightening band according to Claim 1, 2, or 3, wherein the pattern formed on the surface comprises a plurality of types of patterns, and each type of pattern represents identification information of a boot fixing band on which the pattern of the type is formed.
- 20 8. A tightening band according to Claim 1, 2, or 3, wherein the pattern formed on the surface comprises a plurality of types of patterns in one tightening band.
9. A tightening band according to Claim 1, 2, or 3, wherein the member
25 to be tightened is a protective cover for protecting a joint of a rotary shaft of an automobile.

10. A method for producing a tightening band comprising:

a band main body including a ring portion formed by bending a metallic elongated band plate and a band protrusion formed by overlapping and fixing by welding a predetermined length of both end portions of the metallic elongated band plate such that the both end portions face each other;

a lever plate whose top side is protruded outward from the top of the band protrusion and which is fixed to the band protrusion by being welded thereto at the same time when the band protrusion is formed such that the end side of the lever plate is in contact with the outer periphery of the ring portion of the band main body; and

a lever-plate fixing member for fixing the top portion of the lever plate to the band main body by welding,

the diameter of the ring portion of the band main body being reduced by tilting the lever plate until the surface of the lever plate is brought into contact with the outer periphery of the ring portion of the band main body while the end side of the lever plate serving as the fulcrum, so as to apply a tightening force to a member to be tightened,

the method comprising:

forming a pattern of projections and depressions, the difference between the projections and depressions being 2 μm to 30 μm , on reduction rolls used in at least one of rolling steps of rolling each metallic plate as a base material of the band main body, the lever plate, and the lever-plate fixing member;

forming the pattern of projections and depressions having a depth of 2 μm to 30 μm on at least one of the surfaces of the metallic plate by passing

the metallic plate through the reduction rolls; and

cutting the rolled base material into plates for the band main body, the lever plate, and the lever-plate fixing member, so as to produce the tightening band by using the cut plates with the pattern for the band main body, the lever
5 plate, and the lever-plate fixing member.

11. A method for producing a tightening band comprising:

a band main body including a ring portion formed by bending a metallic elongated band plate, a predetermined length of both end portions of
10 the metallic elongated band plate being overlapped,

the diameter of the ring portion of the band main body being reduced so as to apply a tightening force to a member to be tightened,

the method comprising:

forming a pattern of projections and depressions, the difference
15 between the projections and depressions being 2 μm to 30 μm , on reduction rolls used in at least one of rolling steps of rolling a metallic plate as a base material of the band main body;

forming the pattern of projections and depressions having a depth of 2 μm to 30 μm on at least one of the surfaces of the metallic plate by passing
20 the metallic plate through the reduction rolls;

cutting the rolled base material into a plate for the band main body,
and

bending the cut plate with the pattern for the band main body into a ring shape so that the pattern is placed on the inner periphery thereof, so as to
25 form the band main body.

12. A method for producing a tightening band according to Claim 10 or 11, wherein the reduction rolls comprise a plurality of types of reduction rolls so that the pattern differs from one reduction roll to another, and any reduction rolls can be arbitrarily selected from among the reduction rolls and used in the
- 5 rolling step.